

ASAP - GENEVA

Dart Aerospace Ltd.

Date: Friday, 19/01/2007 8:50:23 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 30322
Estimate Number : 12656
P.O. Number : N/A
This Issue : 19/01/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : SMALL /MED FAB
Previous Run : N/A
Written By :
Checked & Approved By :
Comment : Est Rev.:A New Issue 07-01-18 JLM

Drawing Name : BRACKET
Part Number : G106025
Drawing Number : G10608 REV B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 26/01/2007

Qty: Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S14GA 304SS .080



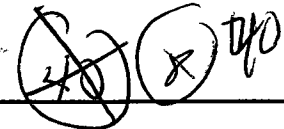
9.4500



Comment: Qty.: 0.9450 sf(s)/Unit Total: 37.8000 sf(s) ml 07 01 26

304SS .080

Batch: ml 07 01 23



2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut-as per Dwg G10608

Dwg Rev: B

Prog Rev: B

ml 07 01 26

ml 07 01 23



2-Deburr if necessary

8B 10m 07/01/24

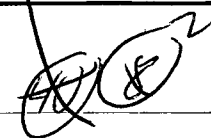
(2)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 01 26
ml 07 01 23



PTO

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

07/01/23 (42)

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

C'SINK AS PER DWG G10608

SAD 07/01/28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: G106025 PAR #: N/A Fault Category: Prod / FAB. ASS ^{med & sm / l} NCR: Yes No DQA: Yes Date: 07/02/01
 QA: N/C Closed: Yes Date: 07.02.01

NCR: <u>30322</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/01/23</u>	<u>3.0</u>	<u>Wrong thickness off material (8 parts)</u>	<u>[Signature]</u> <u>07/01/23</u>	<u>destroy the 8 parts and replace them with the right thickness of material .080"</u>	<u>[Signature]</u> <u>07/01/23</u>	<u>[Signature]</u> <u>07/01/23</u>	<u>[Signature]</u> <u>07/01/23</u>	<u>[Signature]</u> <u>07/01/23</u>

NOTE: Date & initial all entries

Date: Friday, 19/01/2007 8:50:23 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 30322

Part Number: G106025

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/29

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg G10608.

07-01-20

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-01-29 (40)

9.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

Rivet

Batch: M 7681

10.0

MS21047L4

NUT PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

NUT PLATE

Batch: M 103307

SP 07/01/31 40

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg G10608

SP 07/01/31 40

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-01-31 40

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

0740631

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 19/01/2007 8:50:23 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 30322

Part Number: G106025

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207/02/01

Job Completion



U 07-01-31

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

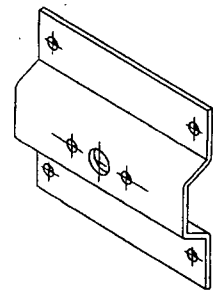
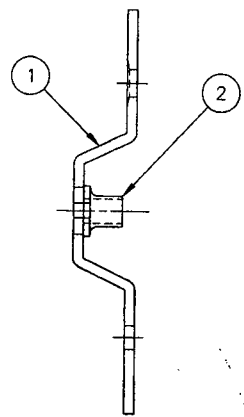
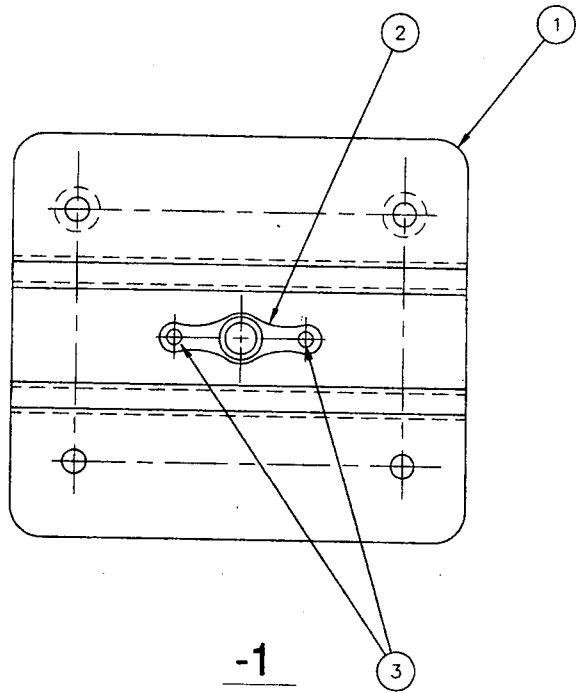
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


NOTE: Date & initial all entries

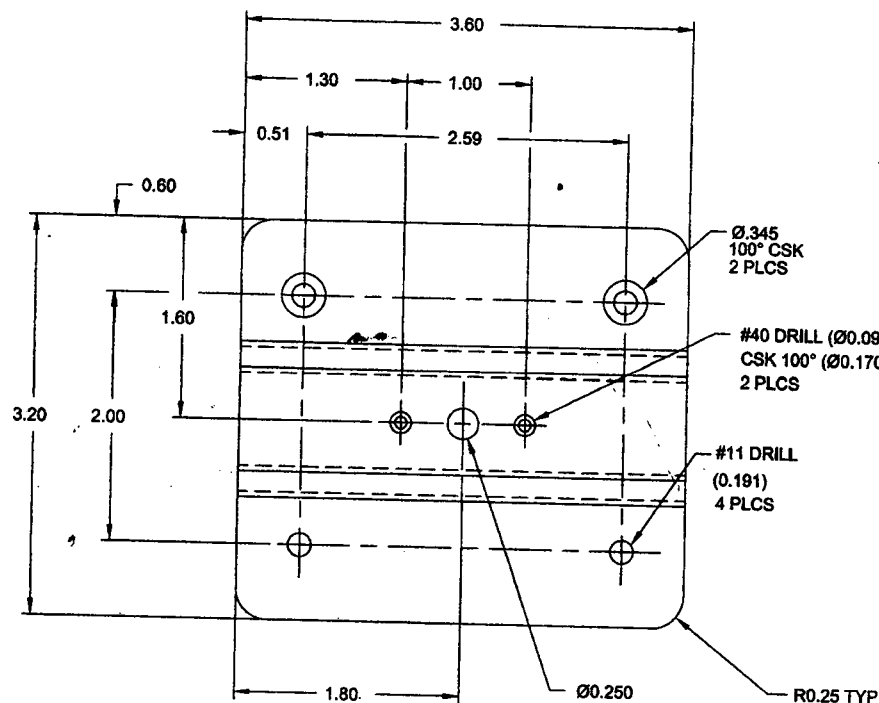
22305
W/b 30322
9/m



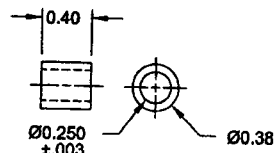
ISOMETRIC VIEW
SCALE: 1/2

REVISION		DATE	APPROV.
REV	DESCRIPTION		
A	- REPLACE PART ITEM #2 & #3.	6-14-95	

	2	3	MS20426-3-3	BENCH STOCK	RIVET
	1	2	MS21047L4	BENCH STOCK	NUTPLATE
	1	1	G10608-1	GENEVA	BRACKET
	-1				
QTY/DASH #	ITEM	PART NUMBER	MANUFACTURER	DESCRIPTION	
BREAK ALL EDGES UNLESS OTHERWISE SPECIFIED DIMENSION ARE IN INCHES DIMENSIONAL TOLERANCES 4 DECIMALS ± 3 DECIMALS ± 2 DECIMALS ± 1 DECIMAL ± ANGULAR ±			DRAWN	T.S.	DATE 3/16/95
			CHECK		DATE
			DESIGN		DATE
			STRESS		DATE
			APPROVAL	RGC	DATE 04/03/95
THIS DRAWING INCLUDES INFORMATION PROPRIETARY TO GENEVA AVIATION AND SHALL NOT BE USED OR DUPLICATED BY ANYONE WITHOUT THE WRITTEN PERMISSION OF GENEVA AVIATION INC.			 GENEVA AVIATION 2817 - 100th Street S.W. Everett, WA 98204 (206)353-7400 FAX(206)347-7100		
			TITLE STAINLESS BRACKET ASSEMBLY		
			DWG NO.	G10602	REV. A
			PRO NO.	GA159	SIZE B SCALE 1/1 SHT. 1

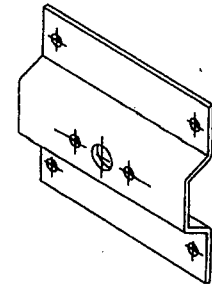
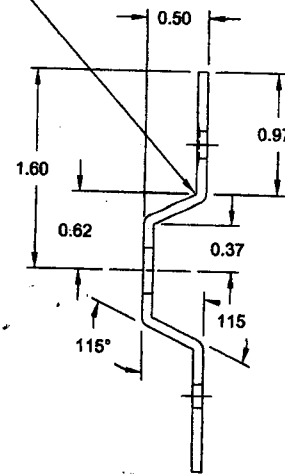


-1



-2

.16 BEND RADIUS
TYPICAL



ISOMETRIC VIEW
SCALE: 1/2

NOTES:

MATERIAL: .075 304 STAINLESS

OPTIONAL: TEXT MAY BE ENGRAVED, STAMPED OR
PRINTED ON PART AS DESIRED

BEND RADIUS +0.01 ON 0.03 TO 0.06
+0.03 ON 0.09 OR GREATER

BREAK SHARP EDGES 125 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMAL ANGLES 1/16" ±.005 1/2" ±.010 .001 ±.001 1/4" ±.005	DESIGNED	T.S.	DATE	3/16/95
	DRAWN		DATE	
	CHECKED		DATE	
	APPROVED	RGC	DATE	4/3/95
THIS DOCUMENT INCLUDES INFORMATION PROPRIETARY TO GENEVA AVIATION AND SHALL NOT BE USED OR DUPLICATED BY ANYONE WITHOUT THE WRITTEN PERMISSION OF GENEVA AVIATION, INC.				
Drawing Number G10608			REV B	
Pro No: GA159			Size: 1:1 Sheet 1 of 1	

Geneva Aviation
www.GenevaAviation.com

Title
STAINLESS BRACKET



Certified in accordance to Pressure Equipment Directive 97/23/EC Annex I,
Paragraph 4.3 by TÜV Anlagentechnik GmbH (Notified Body Identification No.0035)
Inspection Certificate EN10204-3.1B

Shanxi Taigang Stainless Steel CO.,LTD Member of Taiyuan Iron and Steel (Group) Co.,LTD NO.2 jiancaoping, Taiyuan, Shanxi, P.R.China TEL: (0351)3013328 FAX: (0351)3017816 http://www.tisco.com.cn E_mail: tgbxg@tisco.com.cn	QUALITY CERTIFICATE	
	MATERIAL	AISI304 NO 2B FINISH
	SPECIFICATION	ASTM A240/A480-04 ASME SA240/SA480
	L/C NO	
	CERTIFICATE NO.	20050869
	DATE OF ISSUE	11

CUSTOMER	CONTRACT NO.	DATA OF
CMC.	10400	2005/08/20

Product	Melting furnace	Inspectors stamp	Mark of the Manufacturer
COIL	E+VOD		Shanxi Taiyuan Stainless Steel Co.,ltd

NO.	Heat No	Coil No.	Quantity	Dimensions	Weight(Pound)
1	4500933	5A4-301-4ZB	1	24GA x 48 x C	14043
2	4500933	5A4-300-4ZB	1	24GA x 48 x C	13717
3	AHLN1312	5A4-303-4ZB	1	24GA x 48 x C	19372
4	4502513	5A6-355-1ZY	1	14GA x 48 x C	14425
5	Y503096	5A6-470-3ZD	1	14GA x 48 x C	16984
6	4502523	5A6-341-1ZY	1	14GA x 48 x C	16469
Total:			6		95010

Chemical Composition											
Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
4500933	0.050	0.480	1.320	0.023	0.002	18.130	8.050				0.050
4500933	0.050	0.480	1.320	0.023	0.002	18.130	8.050				0.050
AHLN1312	0.053	0.481	1.109	0.029	0.003	18.290	8.100				0.031
4502513	0.060	0.470	1.340	0.014	0.002	18.080	8.140				0.050
Y503096	0.054	0.430	1.050	0.031	0.004	18.180	8.120				0.063
4502523	0.050	0.500	1.340	0.016	0.002	18.040	8.060				0.060

Mechanical Properties								
Test No	Tensile R m N/mm ²	R _{p0.2} Yield _{0.2%} N/mm ²	R _{p1.0} Yield _{1.0%} N/mm ²	Elongation A5%	Corrosion Tests	Hardness		
						HRB	HV	HRC
4500933-T	645	295		58			174	
4500933-T	645	295		58			174	
AHLN1312-T	685	294		54			182	
4502513-T	650	301		61		84 - 83		
Y503096-I	665	319		57		86 - 86		
4502523-T	640	297		62		83 - 82		
-T								

Surface and dimensions controlled: O.K.

Work Inspection